

76211

Monday, November 07, 2011 2:42:13 PM

N900040100

Setup Start *NS1*

Stop *NS2*

6

6

Reference:

Run Start *NR1*

Stop *NR2*

Date:

Insp.
Stamp

0.00

130

HAAS CNC VERTICAL MACHINING #1

0.00

HAAS 1

HAAS CNC vertical machine #1

Memo

Machine as per Folio FA532 and Dwg D3401

Dwg Rev: **B**

Folio Rev: 24

Identify as D3401-1

Deburr & Buff rad as per Dwg D3401

135

0.00

135

QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Quality Control

Memo

140

0.00

140

QC8- Inspect parts - second check

0.00

OC

Quality Control

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Item ID: D3401-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Tow Cap Assembly
 Start Date: 11/7/2011 Start Qty: 6.00 ***6*** Cust Item ID:
 Required Date: 11/16/2011 Req'd Qty: 6.00 ***6*** Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
180 Powdercoat Powder Coating	Memo START TIME: 2:00 OVEN TEMPERATURE: 320°F FINISH TIME: 2:30	0.00							12X4M-11/12/22
190	QC3- Inspect Part Finish	0.00							
190 QC Quality Control	Memo	0.00							12/01/16
195	Assemble as per dwg	0.00							
195 HandFinish Hand Finishing	Memo	0.00							12/01/19

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Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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200 QC5- Inspect part completeness to step on W/O 0.00

200

QC

Quality Control

Memo

0.00

210

Identify as per dwg & Stock Location: FP-2

0.00

210

Packaging

Packaging

Memo

0.00

220

QC21- Final Inspection - Work Order Release

0.00

220

QC

Quality Control

Memo

0.00

12/11/23

12/20/20
(H)

Picklist Print

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Work Order ID: 76211

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Parent Item: D3401-041

D3401-041

Parent Item Name: Tow Cap Assembly

Start Date: 11/7/2011

Required Date: 11/16/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP A05.09.01New issueKJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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NAS1330C3KB116 Purchased No

NAS1330C3KB116

Insert

Location

Loc Qty

Loc Code

ST276

678

102606

200

103185

36

103337

442

M6061T6R3.500 Purchased No

M6061T6R3.500

6061 RD bar 3.50

Location

Loc Qty

Loc Code

MAT005

15.027

116808

3.027

119231

12

MAT036

5.67

110993

5.67

**

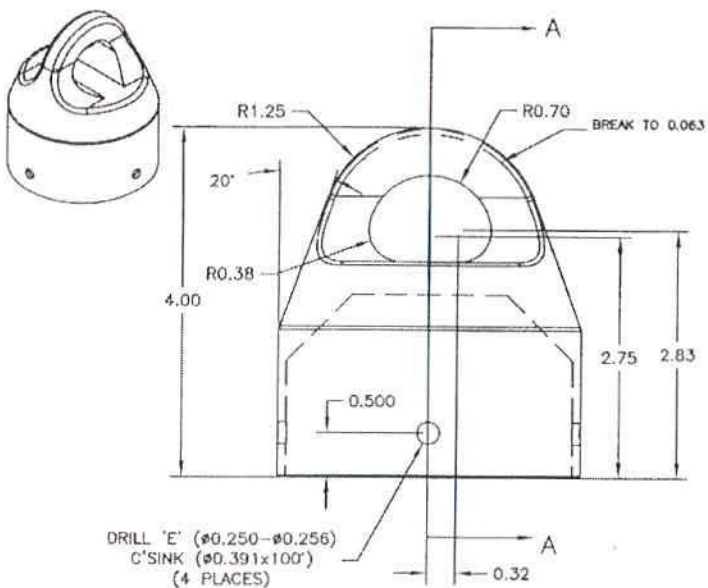
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24 ~~116~~ 16
11/10/2011 11/10/11

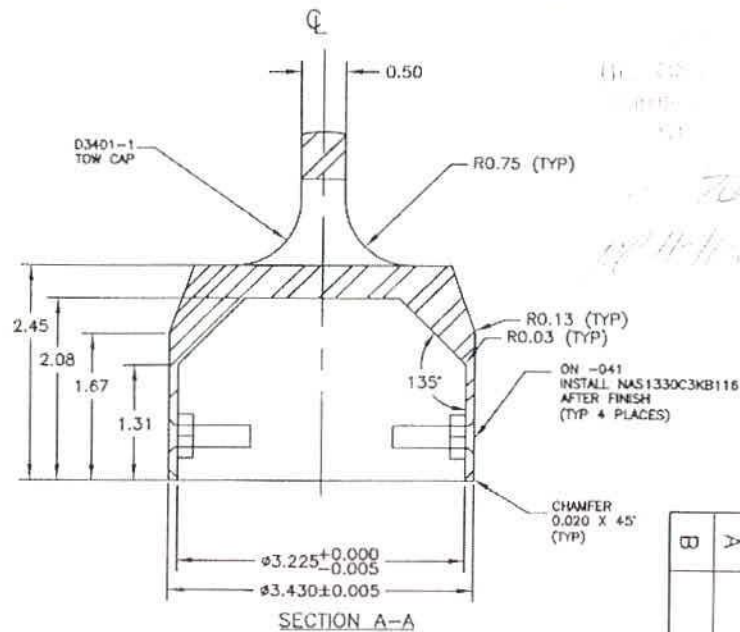
~~116~~ 16

~~2.210526~~ 11/10/28

~~7.511~~



D3401-1 TOW CAP



D3401-1/-041 TOW CAP

D3401-1 TOW CAP

- 1) MATERIAL: MAKE FROM ALUMINUM 6061-T6 ø3.500 ROUND BAR PER QQ-A-225/8 OR AMS-QQ-A-200/8 (REF. DART SPEC M6061T6R3.5000)
- 2) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.015
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

D3401-041 TOW CAP

- 1) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5:1) PER DART QSI 005 4.3

D3401-041 TOW CAP PARTS LIST

QTY	PART NUMBER	DESCRIPTION
1	D3401-1	TOW CAP
4	NAS1330C3KB116	INSERT

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
PH	PH	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO.
		D3401
DATE	TITLE	REV. B
05.06.09	TOW CAP	SHEET 1 OF 1
	NEW ISSUE	SCALE
	CHAMFER INSIDE, REMOVE RADIUS	1:2

RELEASED
05-08-07